

NOV 23

Work Order ID 76324

76324

November-09-11 8:33:09 AM

Item ID: D4017-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Short Basket Base Assembly (350)
Start Date: 09/11/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 23/11/2011 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: M.C.J Date: 11/11/09 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	C								

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00
Large Fab
100
Large Fab Memo 0.00
Large Fab

Memo
1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

11/11/15 1/2

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
QC Memo 0.00
Quality Control

BF
11.11.16

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76324

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 09/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 23/11/2011 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

Solution

IX 0 m 11/11/15

W/O:		WORK ORDER CHANGES					
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Work Order ID 76324***76324***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 11:20OVEN TEMPERATURE: 400 OFFINISH TIME: 11:50

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

*XO M / 11/11/17**1 BR 11-11-17**M 118439*

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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		
DATE	STEP	

Part No: _____

Resolution: _____

NCR:		
DATE	STEP	Descrip Ser

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-09-11 8:33:14 AM

Page 1

Work Order ID: 76324

76324

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4017-1

Manufactured

No

100

Each

2.0000

1

1

D4017-1

Rib

**

Location

Loc Qty

Loc Code

WA

2

59957

0

71993

2

D4018-1

Manufactured

No

Each

5.0000

D4018-1

Rib

**

Location

Loc Qty

Loc Code

WA

5

72545

5

D4018-1 is the same as D4017-3

D4017-5

Manufactured

No

100

Each

3.0000

1

1

D4017-5

Hinge Rib

**

Location

Loc Qty

Loc Code

WA

3

71106

1

72558

2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 76324

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Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-041
D4034-041
Aft Upper Rib Assembly

Manufactured No

100 Each 2.0000 1 1

**

B74806 → (1x) 11/11/11

Location

Loc Qty

Loc Code

WA006

2

69157

1

74139

1

✓ D4034-043
D4034-043
Fwd Upper Rib Assembly

Manufactured No

100 Each 2.0000 1 1

**

B74784 → (1x) 11/11/11

Location

Loc Qty

Loc Code

WA

1

74146

1

WA006

1

70241

1

✓ D2581
D2581
Mounting Bracket

Manufactured No

100 Each 23.0000 2 2

**

11/11/11

Location

Loc Qty

Loc Code

WA

23

69739

2

70766

2

73762

19

✓ D3913-15
D3913-15
Wide Handle Plate

Manufactured No

100 Each 9.0000 1 1

**

11/11/11

Location

Loc Qty

Loc Code

WA

8

74640

8

WA005

1

69012

1

November-09-11 8:33:14 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-1
D4016-1
Hinge Half, Base

Manufactured No

100 Each 22.0000 3 3

**

Handwritten: 11/11/11

Location

Loc Qty

Loc Code

WA

22

66418

0

68426

3

72757

1

74140

18

Handwritten: (3x)

✓ D4020-3
D4020-3
Mesh (350 Basket Short, Base)

Manufactured No

100 Each 0.0000 1 1

**

Handwritten: B 76330 → 1x 11/11/11

D4020-11

Manufactured No

100 Each 7.0000 2 2

**

Handwritten: B 74035 → 1x 11/11/11

✓ ***D4020-11***
End Mesh, Basket

Location

Loc Qty

Loc Code

WA

7

69648

2

74035

1

74386

4

Handwritten: B 74386 → 1x

✓ D4021-1
D4021-1
Handle Plate

Manufactured No

100 Each 33.0000 3 3

**

Handwritten: 11/11/11

Location

Loc Qty

Loc Code

WA

33

69518

6

74316

9

74946

9

74986

9

Handwritten: (3x)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No

150 Each 558.0000 2 2

D2931

Bumper

**

Location

Loc Qty

Loc Code

ST504

558

46064

558

D4021-5 Manufactured No

150 Each 25.0000 2

D4021-5

Blanking Plate

**

Location

Loc Qty

Loc Code

GA

25

73478

25

AN3-10A Purchased No

150 Each 150.0000 6

AN3-10A

Bolt

**

Location

Loc Qty

Loc Code

GA

95

119084

95

ST351

55

117795

39

119128

16

AN960JD8 NAS1149DN832 Purchased No

150 Each 0.0000 2 2

AN960JD8

Washer

**

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D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,313.000

2

2

MS20600-AD4W3

Cherry Rivets

**

Handwritten signature

Location

Loc Qty

Loc Code

GA

880

118626

880

118626

ST321

300

111636

48

117505

217

117601

35

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

9,347.000

6

6

MS21042L3

Nut

**

Handwritten signature and date 11/11/11

Location

Loc Qty

Loc Code

ST300

367

117441

16

117885

42

118451

5

118927

304

ST516

6000

119017

6000

ST518

2980

119075

2980

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

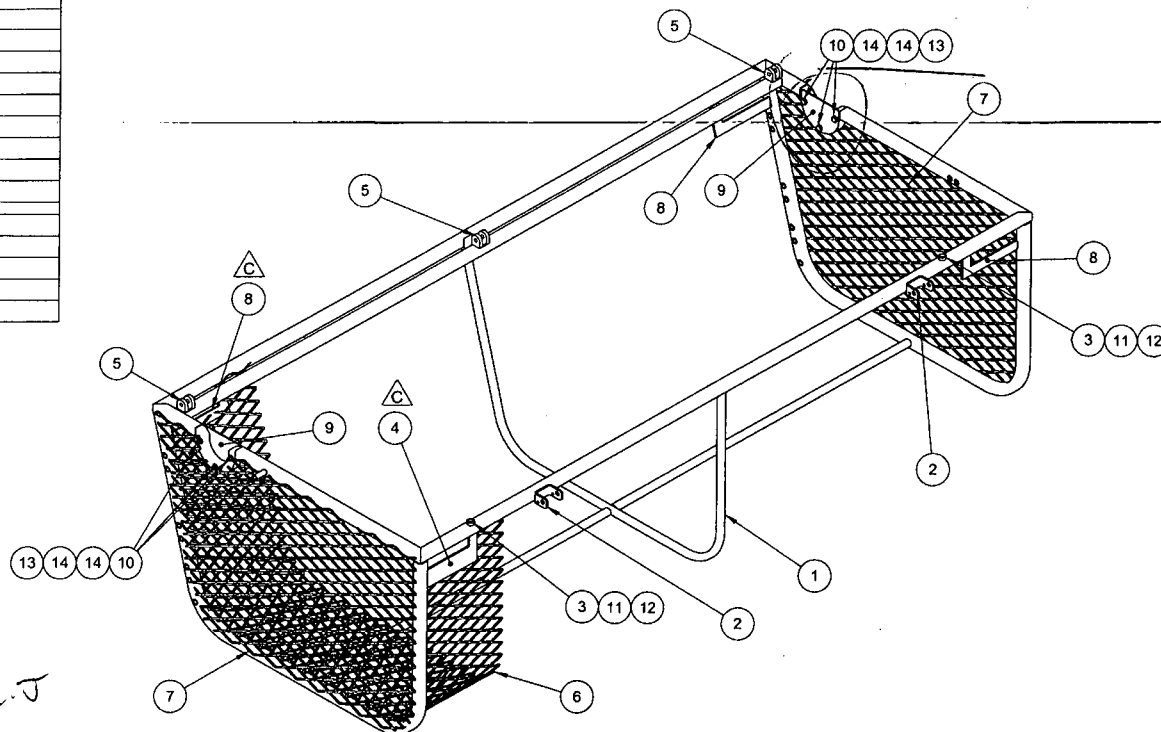
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 76324 M.C.J

11/11/09

D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.06.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D8-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3-10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D8-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	31.5.04		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350)** SCALE NTS

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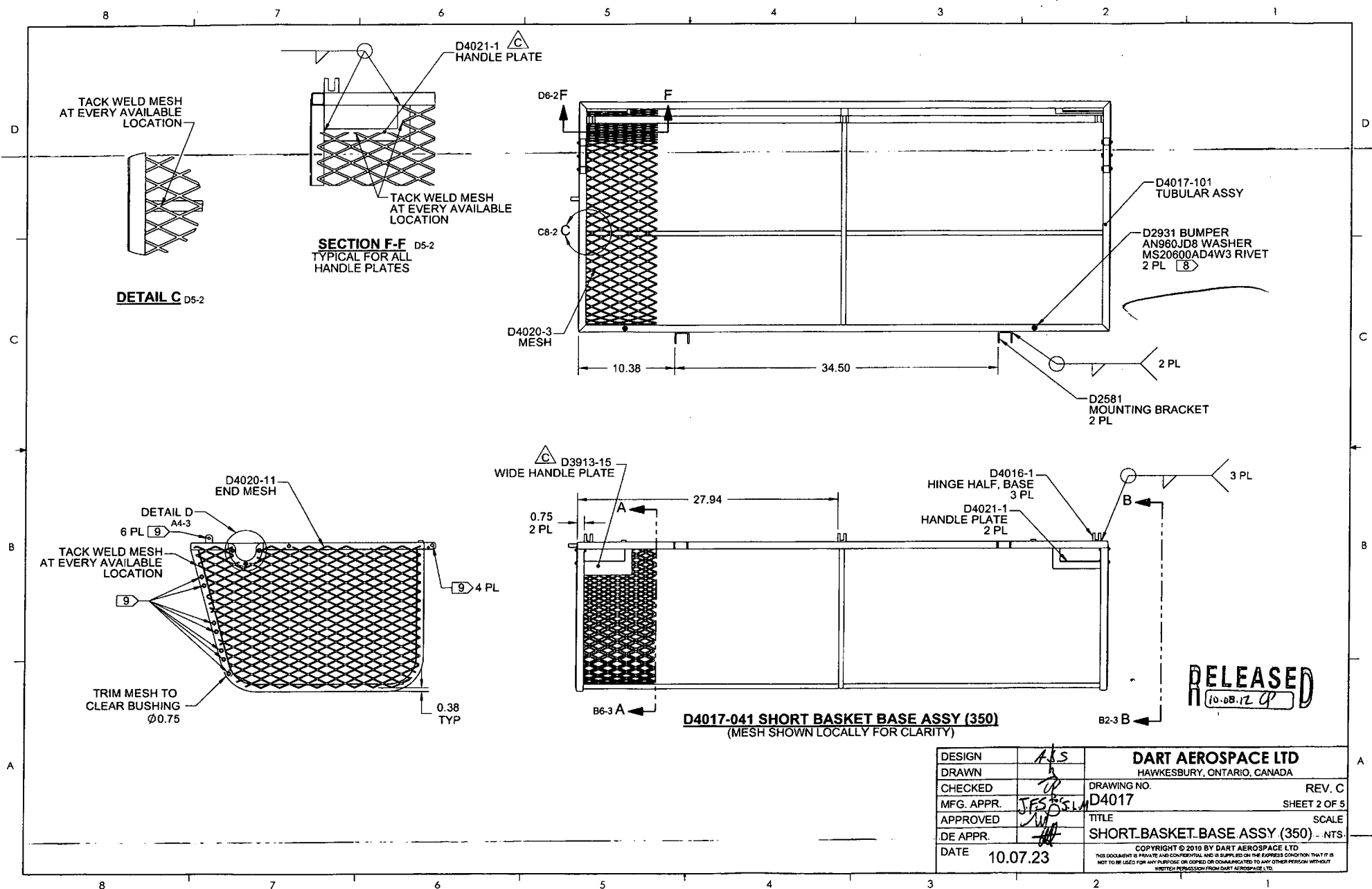
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76324



DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JES	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JES	DRAWING NO. D4017	REV. C
MFG. APPR.	JES	SHEET 2 OF 5	
APPROVED	JES	SCALE	
DE APPR.	JES	SHORT.BASKET.BASE ASSY (350) - NTS-	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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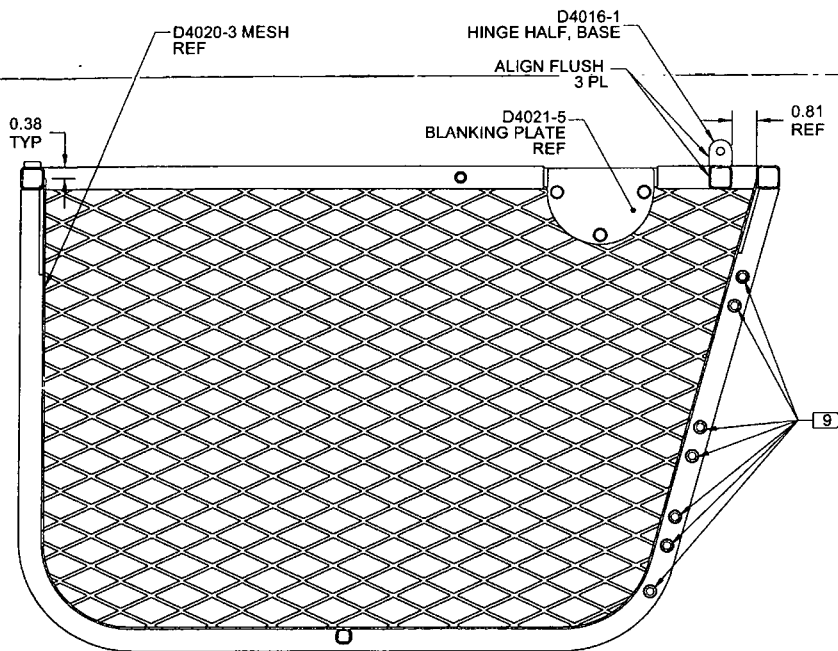
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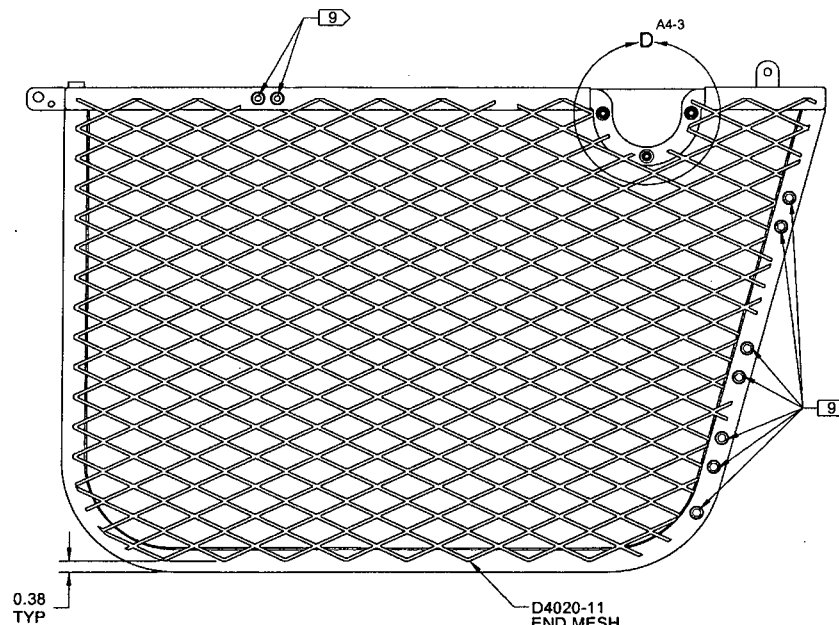
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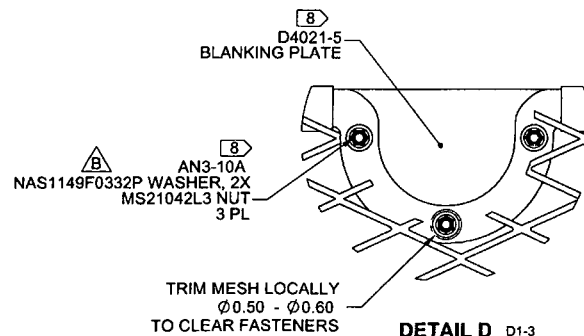
76324



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

RELEASED
10.08.12.42

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. ^{BY} J.F.S.	D4017	SHEET 3 OF 5
APPROVED	J.F.S.	TITLE	SCALE
DE APPR.	J.F.S.	SHORT-BASKET-BASE ASSY (350) -NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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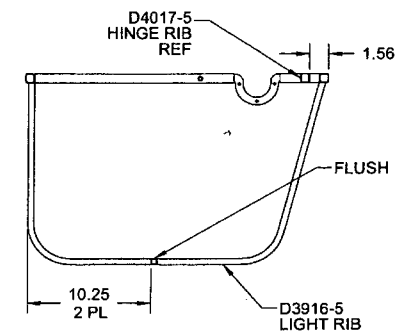
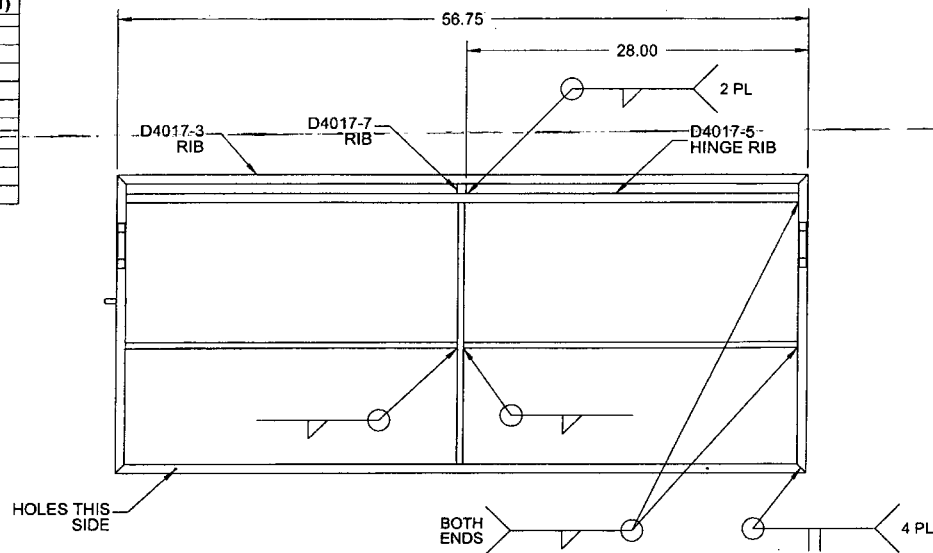
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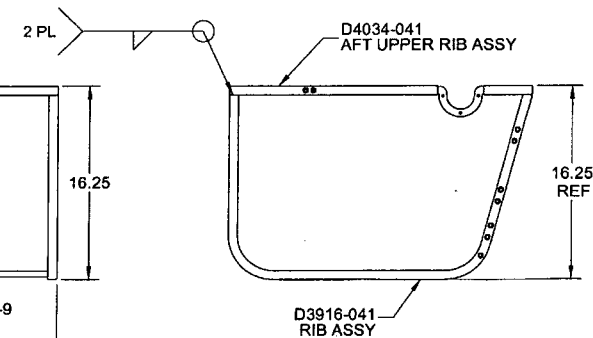
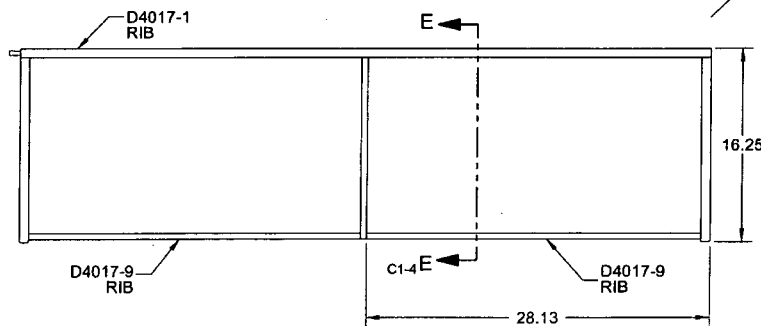
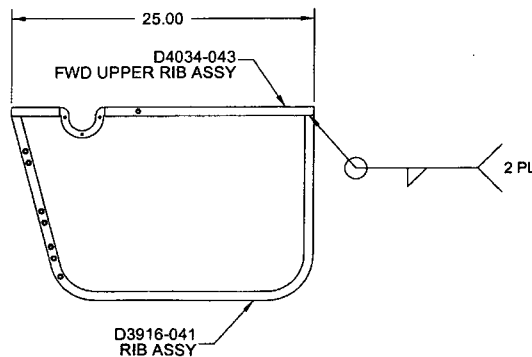
NOTE: Date & initial all entries

76324

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 15.26 lbs
 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	RELEASED 100812	
DRAWN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	STP	D4017	SHEET 4 OF 5
APPROVED	JM	TITLE	SCALE
DE APPR.	JM	SHORT BASKET-BASE ASSY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

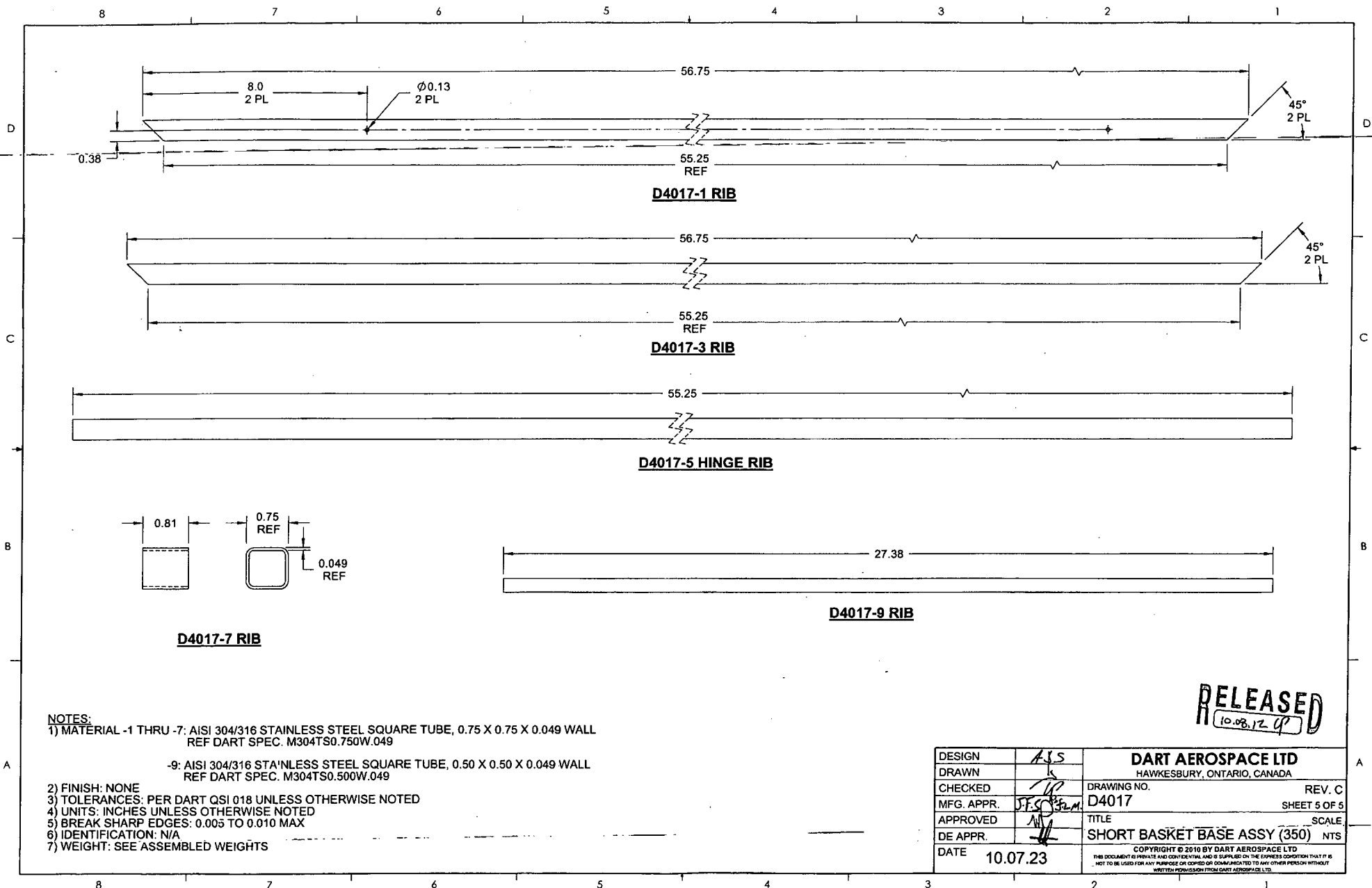
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76324



RELEASED
 10.08.12 9

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries